

Work Order ID 73272

Monday, August 29, 2011 3:17:35 PM



Page 1

Item ID: K642-511

Accept



Setup Start



Revision ID:

Stop



Item Name: saddle kit 642-511

Start Date: 8/29/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 9/2/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: *JMK*Date: *11-08-29*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSI 9467

Rev A

IIN D206-642

Rev N

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Create White labels per PPP K642-511

CHG004

*8/30/12**11/8/11 CL 11-8-31*

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/11/11 3

Work Order ID 73272

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Page 2

Item ID: K642-511

Accept



Setup Start



Revision ID:

Stop



Item Name: saddle kit 642-511

Start Date: 8/29/2011 Start Qty: 3.00



Cust Item ID:

Required Date: 9/2/2011 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/30/12

75

130

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP K642-511 Location: PK

RCOB

11/4/12 (3)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/12 MF 11-09-22

Picklist Print

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Page 1

Work Order ID: 73272

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/29/2011

Required Date: 9/2/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev.A 07.06.05 new issue EC
IPP Rev.B 08.02.05, Per ECN1080P LL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C35A BOLT		Purchased	No			110	Each	65.0000	3	9			

Location	Loc Qty	Loc Code
FG	4	
18914	4	
ST352	16	
117366	16	
ST353	45	
117872	25	
118628	20	

AN3C36A BOLT		Purchased	No			110	Each	89.0000	9	27			
-----------------	--	-----------	----	--	--	-----	------	---------	---	----	--	--	--

Location	Loc Qty	Loc Code
FG	14	
101261	4	
116590	10	
FP-B	17	
111925	17	
ST353	58	
118191	23	
118451	20	
118706	15	

11/9/15 SL-30
m118757 (82)
4x
15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 73272

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/29/2011

Required Date: 9/2/2011

Start Qty: 3.00

Required Qty: 3.00

AN3C41A


Purchased

No

110

Each

73.0000

8

24 ^{12x}



1118757

[Handwritten signature]

BOLT

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

69

117950

19

118518

50

12x

AN4C6A


Purchased

No

110

Each

349.0000

12



36

[Handwritten signature]

Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

345

116704

15

117872

30

118191

100

118451

200

30

AN5C11A


Purchased

No

110

Each

164.0000

8



24

116/15

[Handwritten signature]

Bolt

Location

Loc Qty

Loc Code

FG

4

104817

4

ST337

110

117872

40

118706

70

ST338

50

118191

50

8

16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 3

Work Order ID: 73272

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/29/2011

Required Date: 9/2/2011

Start Qty: 3.00

Required Qty: 3.00

AN5C12A

Purchased

No

110

Each

67.0000

4



BOLT

Location

Loc Qty

Loc Code

FG

2

18918

2

ST338

65

117313

15

118451

50

AN5C13A

Purchased

No

110

Each

84.0000

4



BOLT

Location

Loc Qty

Loc Code

FG

4

18918

4

ST338

80

117313

30

117872

50

AN5C15A

Purchased

No

110

Each

95.0000

1



Bolt

Location

Loc Qty

Loc Code

ST338

23

118191

23

ST339

72

117885

22

118267

50

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 73272

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/29/2011

Required Date: 9/2/2011

Start Qty: 3.00



Required Qty: 3.00

S₄₃ AN5C32A Purchased No 110 Each 91.0000 2  6 



Location	Loc Qty	Loc Code
FG	4	
18918	4	
ST340	87	
<u>116380</u>	37	B
117407	25	
117969	25	

S₄₃ AN5C34A Purchased No 110 Each 48.0000 2  6 

Location	Loc Qty	Loc Code
FG	2	
18918	2	
ST340	46	
<u>117763</u>	21	6
117950	25	

S₄₃ AN5C35A Purchased No 110 Each 61.0000 1  3 

Location	Loc Qty	Loc Code
ST340	36	
<u>108407</u>	36	3
ST341	25	
118451	25	

S₄₃ AN960C10L NAS1149C0332 R Purchased No 110 Each 0.0000 24 72  M118354 11/9/15 

washer

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 73272



Parent Item: K642-511



Parent Item Name: saddle kit 642-511

Start Date: 8/29/2011

Required Date: 9/2/2011

Start Qty: 3.00

Required Qty: 3.00

D2712.

Manufactured No

110

Each

531.0000

10

30



Set Screw



Location

Loc Qty

Loc Code

FG

50

29962

50

ST021

481

71160

181

72231

300

30

D2932-1

Manufactured No

110

Each

5.0000

1

3



Saddle LH Out, 206



Location

Loc Qty

Loc Code

ST428

5

69922

1

70874

4

1

D2933-1

Manufactured No

110

Each

10.0000

1

3



Saddle LH In, 206



Location

Loc Qty

Loc Code

ST421

1

71062

1

ST428

9

70875

3

72884

6

3

11/9/15 SP (3)

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Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 73272

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/29/2011

Required Date: 9/2/2011

Start Qty: 3.00

Required Qty: 3.00

D2934

Manufactured No

110

Each

33.0000

2



Saddle Spacer

Location

Loc Qty

Loc Code

FG

6

31929

6

ST027

27

70772

27

Manufactured No

110

Each

25.0000

2

D2935



Saddle Spacer

Location

Loc Qty

Loc Code

ST027

25

70770

25

Manufactured No

110

Each

4.0000

1

D2938-1



Saddle LH Out, 206

Location

Loc Qty

Loc Code

ST428A

4

70862

4

Manufactured No

110

Each

5.0000

1

D2939-1



Saddle LH In, 206

Location

Loc Qty

Loc Code

ST421

1

71056

1

ST428A

4

71873

4

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 73272

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/29/2011

Required Date: 9/2/2011

Start Qty: 3.00

Required Qty: 3.00

D3396-3

Manufactured No

110

Each

11.0000

2



Spacer



6
B 73349 11/9/11

Location

Loc Qty

Loc Code

FG

10

26772

10

ST052

1

70983

1

Manufactured No

110

Each

8.0000

1

D3407-043



Tow Ring



3
B71575 11/9/11

Location

Loc Qty

Loc Code

ST463

6

70982

5

72513

1

ST464

2

68339

2

Manufactured No

110

Each

51.0000

1

D3456-1



Washer



3
11/9/11 ③

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

44

66848

3

71165

41

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 73272

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/29/2011

Required Date: 9/2/2011

Start Qty: 3.00

Required Qty: 3.00

D3457-1

Manufactured No

110

Each

56.0000

2

Washer

Location

Loc Qty

Loc Code

FG

10

32409

10

ST054

46

67779

1

71849

45

Manufactured No

110

Each

1,178.000

24

D3672-1

Phenolic Washer

Location

Loc Qty

Loc Code

ST074

1176

64177

180

66821

496

72229

500

ST077

2

52505

2

Manufactured No

110

Each

767.0000

24

D3672-3

Phenolic Washer

Location

Loc Qty

Loc Code

ST074

767

64176

225

71159

42

72230

500

Monday, August 29, 2011 3:17:29 PM

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Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, August 29, 2011 3:17:29 PM

Work Order ID: 73272

Parent Item: K642-511

Parent Item Name: saddle kit 642-511

Start Date: 8/29/2011

Required Date: 9/2/2011

Start Qty: 3.00

Required Qty: 3.00

D3672-7

Manufactured No

110 Each

414.0000

24

72



Phenolic Washer



42
373188

5

Location

Loc Qty

Loc Code

ST074

414

53237

244

64175

170

MS21043-3

Purchased No

110 Each

1,376.000

20

60



Nut



24
60

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1304

112314

6

118077

298

118614

500

118686

500

MS21043-4

Purchased No

110 Each

1,376.000

13

39



Nut



11/9/14

3x

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1336

117793

480

118378

356

118686

500

39

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, August 29, 2011 3:17:29 PM

Work Order ID: 73272



Parent Item: K642-511



Parent Item Name: saddle kit 642-511

Start Date: 8/29/2011

Required Date: 9/2/2011

Start Qty: 3.00

Required Qty: 3.00

MS21043-5

Purchased

No

110

Each

504.0000

4

12



Nut



119/135/30

Location

Loc Qty

Loc Code

FG	20	
101418	20	
ST301	384	
112314	284	
116548	100	
ST314	100	
118159	100	

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D206-642

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4.7 206L/L-1/L-3/L-4/407 HIGH GEAR FLOAT SKIDTUBES (TRI-BAG COMPATIBLE)

ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
	X									D206-642-511	SKIDTUBE INSTALLATION, LH
		X								D206-642-512	SKIDTUBE INSTALLATION, RH
			X							D206-642-515	SKIDTUBE INSTALLATION, LH
				X						D206-642-516	SKIDTUBE INSTALLATION, RH
	1	1			X					D206-642-541	SKIDTUBE
						X				D206-642-547	WEARSHOE KIT (REPLACES -543 KIT)
							X			D206-642-549	RUN-ON LANDING WEARPLATE KIT
			1	1				X		D206-642-551	SKIDTUBE
	1	1	1	1					X	D206-648-013	GROUND HANDLING KIT
1					1					D3274-041	SKIDTUBE ASSEMBLY
1								1		D4362-041	SKIDTUBE ASSEMBLY
3					1			1		D2646	* AFT CAP ⁽¹⁾
4					2			2		AN3C4A	* BOLT ⁽¹⁾
5A					2			2		NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
5B					2			2		D3672-1	* WASHER (REPLACES NAS1515H3L) ⁽¹⁾
6	1		1							D2932-1	SADDLE, FWD OUT, LH
6		1		1						D2932-2	SADDLE, FWD OUT, RH
7	1		1							D2933-1	* SADDLE, FWD IN, LH
7		1		1						D2933-2	SADDLE, FWD IN, RH
8	1		1							D2938-1	SADDLE, AFT OUT, LH
8		1		1						D2938-2	SADDLE, AFT OUT, RH
9	1		1							D2939-1	* SADDLE, AFT IN, LH
9		1		1						D2939-2	SADDLE, AFT IN, RH
10	8	8	8	8						AN3C41A	* BOLT
11	16	16	16	16						D2652	BUSHING
12A	8	8	8	8						MS21043-3	* NUT
12B	16	16	16	16						D3672-7	WASHER (REPLACES NAS1515H5)
13	4	4	4	4						AN5C11A (or AN5C12A)	* BOLT ⁽²⁾
14	4	4	4	4						AN5C11A (or AN5C13A)	* BOLT ⁽²⁾
15A	8	8	8	8						NAS1149C0532R	WASHER (OR AN960C516L)
15B	8	8	8	8						D3672-7	WASHER (REPLACES NAS1515H5L)
16	12	12	12	12						AN4C6A	BOLT
17A	24	24	24	24						D3672-3	WASHER (REPLACES NAS1515H4L)
17B	24	24	24	24						NAS1149C0432R	WASHER (OR AN960C416L)
18	12	12	12	12						MS21043-4	NUT
20A					9	9				D3537-1	* WEARPAD ⁽¹⁾ (REPLACES D2648-3)
21A					1	1				D3537-3	* WEARPAD ⁽¹⁾ (REPLACES D3429-1)
22A					1	1				D3535-15	* WEARSHOE ⁽¹⁾ (REPLACES D2656-15)
22B					1	1				D3536-15	* GASKET ⁽¹⁾
23A					1	1				D3535-23	* WEARSHOE ⁽¹⁾ (REPLACES D2656-23)
23B					1	1				D3536-23	* GASKET ⁽¹⁾
24A					1	1				D3535-39	* WEARSHOE ⁽¹⁾ (REPLACES D3287-1)
24B					1	1				D3536-39	* GASKET ⁽¹⁾
25A					1	1				D3535-35	* WEARSHOE ⁽¹⁾ (REPLACES D2656-35)
25B					1	1				D3536-35	* GASKET ⁽¹⁾
26A			8	8	78	78	8			AN3C4A	* BOLT ⁽¹⁾
26B			8	8	78	78	8			NAS1149C0332R	* WASHER ⁽¹⁾ (OR AN960C10L)
26C			8	8	78		8			ALS7-1032-130	* INSERT ⁽¹⁾ (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
30	1	1	1	1						D3407-043	TOW RING
32A	1	1	1	1						D3456-1	WASHER
32B	2	2	2	2						D3457-1	WASHER
33	1	1	1	1						MS21043-4	NUT
34			1	1	1					AN4C5A	BOLT
35			1	1	1					NAS1149C0463R	WASHER (OR AN960C416)
36			1	1	1					D3413-1	RING
37	10	10	10	10						D2712	SET SCREW
38	2	2	2	2						D2934	SADDLE SPACER
39	2	2	2	2						D2935	SADDLE SPACER

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Revision: 0
Date: 11.06.15

ITEM	QTY -511	QTY -512	QTY -515	QTY -516	QTY -541	QTY -547	QTY -549	QTY -551	QTY -013	PART NUMBER	DESCRIPTION
40									2	D3414-041	LUG ASSEMBLY (GHW)
41									4	AN3C37A	BOLT
42									8	D2652	BUSHING
43									4	MS21043-3	NUT
44									4	NAS1149C0363R	WASHER (OR AN960C10)
50	9	9	3	3						AN3C36A	BOLT
51	3	3	3	3						AN3C35A	BOLT
52	24	24	12	12						NAS1149C0332R	WASHER (OR AN960C10L)
53	24	24	12	12						D3672-1	WASHER (REPLACES NAS1515H3L)
54	12	12	6	6						MS21043-3	NUT
55	2	2	2	2						D3396-3	SPACER
56A	1	1	1	1						AN5C35A	BOLT
56B	1	1	1	1						AN5C15A	BOLT
60	2	2	2	2						AN5C32A	BOLT
61	2	2	2	2						AN5C34A	BOLT
62	4	4	4	4						MS21043-5	NUT
80							1	1		D4368-041	FWD WEARPLATE ASSY
81							1	1		D4368-043	AFT WEARPLATE ASSY
82A							1	1		D4383-1	WEARPAD
82B							1	1		D4383-3	WEARPAD
83							20	20		D3873-3	BUSHING
84								24		D3411-3	WASHER
85							2			D3275-1	SPACER
86A							6	6		AN3C40A	BOLT
86B							2	2		AN3C37A	BOLT
86C							2	2		AN3C36A	BOLT
87							10	10		MS21043-3	NUT

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3274-041 OR D4362-041 ASSEMBLY ABOVE
(2) CHOICE OF BOLT WILL DEPEND ON CROSSTUBE (SEE INSTALLATION PROCEDURE)

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